

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014272**Date Inspected:** 26-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder( OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

Segment # 7AE

This Quality Assurance (QA) Inspector witnessed final tension verification for Lower Chevron Angle (Bike Path & Cross Beam side) at Panel Point (PP) 48~ 49, Segment 7AE Inspected 100% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00331 Dated April 26, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220018 and final torque required was Rotation of Nut 180 degree.

At Segment 7AE at Panel Point (PP) 48 and PP 49 for Lower Chevron Brace (Bike Path & Cross Beam side) Bolt Size used was M22 x 75 RC Set# DHGM220005 and final torque required was 473 N-m respectively and Notification No. 00331 Dated April 26, 2010.

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### Segment # 7CW-PP55

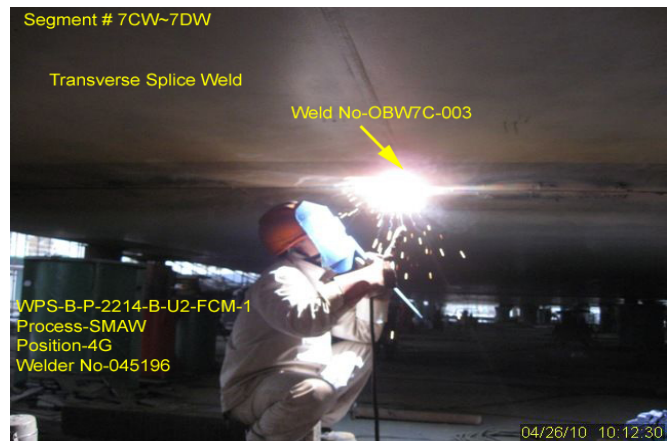
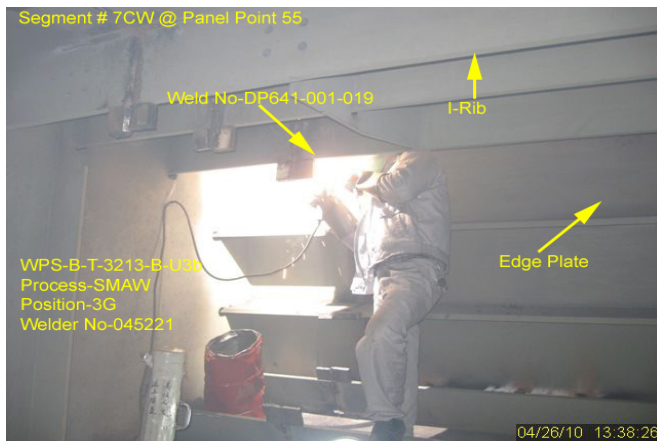
This QA inspector observed, ZPMC qualified welding personnel identified as 045221 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP641-001-019; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-B-U3b. See the attached below Photo.

### Segment # 7CW~7DW

This QA inspector observed, ZPMC qualified welding personnel identified as 045196 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW7C-003; ZPMC QC is identified as Mr. Wang Zhu. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1. See the attached below Photo.

### Segment # 8AE

This QA inspector observed, ZPMC qualified welding personnel identified as 067904 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG044A-027; ZPMC QC is identified as Mr. Wang Zhu. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1.



### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

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Inspected By: Prabhune,Manoj

Quality Assurance Inspector

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**Reviewed By:** Patterson,Rodney

QA Reviewer